

Date: Thursday, 31/07/2008 12:19:00 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 40858
 Estimate Number : 12505
 P.O. Number :
 This Issue : 31/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 37429
 Written By :
 Checked & Approved By : JLD 08.8.01
 Comment : Est Rev:C Removed Manufacturing 06-08-02 JLM
 Est Rev:D ECN 1052 07-11-06 DD verified by: EC

Drawing Name : N1 GEARBOX ACCESS PANEL KIT
 Part Number : D412705017
 Drawing Number : D3255 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 07/08/2008 Qty: Um: Each

SPILT
1

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD412-705-017 CHG001

508/08/01

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0 D3255041 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Access Panel Assembly
 Batch: B33603

SC

SC

4.0 D3255042 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Access Panel Assembly
 Batch: B33604

SC

SC

5.0 AN3C3A Bolt



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)
 Bolt
 Batch: M108521

M108827

8/8/01

59

SC

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 12:19:00 PM
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Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 40858

Part Number: D412705017

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 MS20427M33 Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 72.0000 Each(s)

Rivet

Batch: M108473

SD

7.0 MS21060L3K Nut Plate



Comment: Qty.: 18.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nut Plate

Batch: M107519

M108521

29 M108827

SD

8.0 MS932109 Washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

M108521

M108827

(X)

9.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50060/01 (X)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-705-017

Location:

PPP Rev:

Rev A

8/18/11

SD

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

120808/12

Job Completion



MF 08-08-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

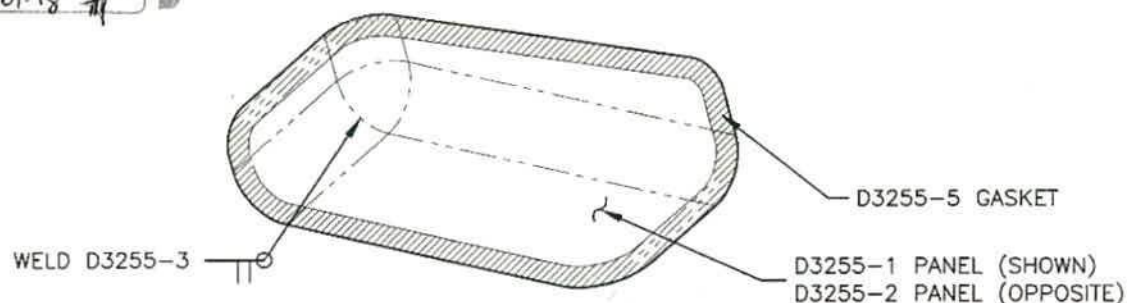
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

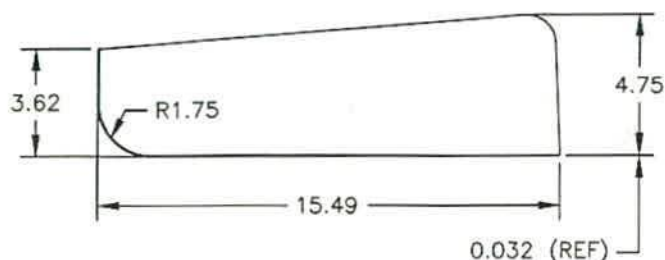
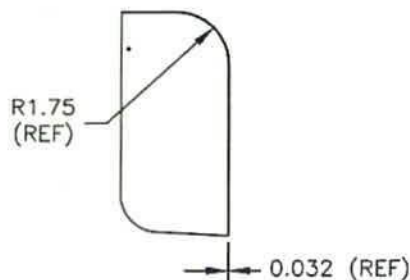
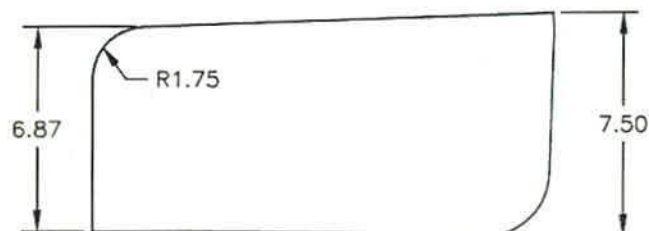
NOTE: Date & initial all entries

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

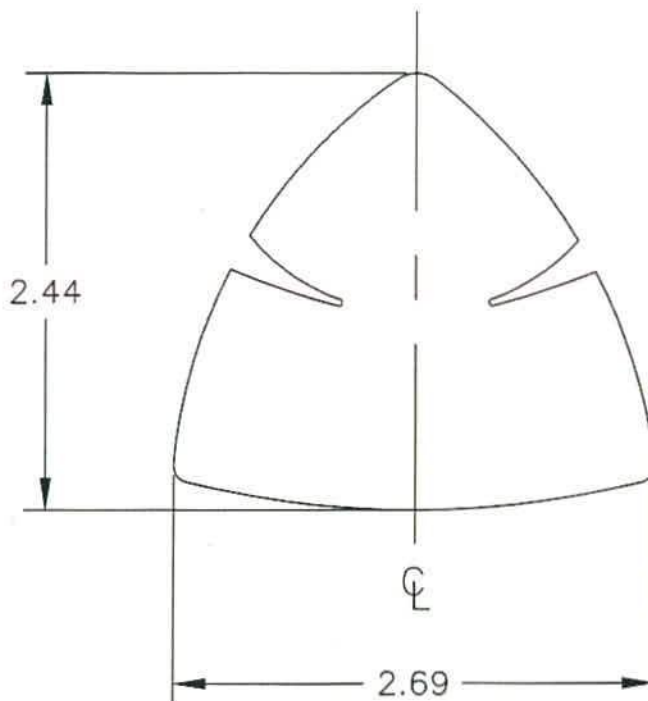
SHOP COPY
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WORK ORDER
NO. 40858

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DART

DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18 [Signature]

D3255-3 CAP
FORM TO FIT D3155-1/-2

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WITHOUT NOTICE
WORK ORDER
NO. 40858

D3255-3 NOTES:

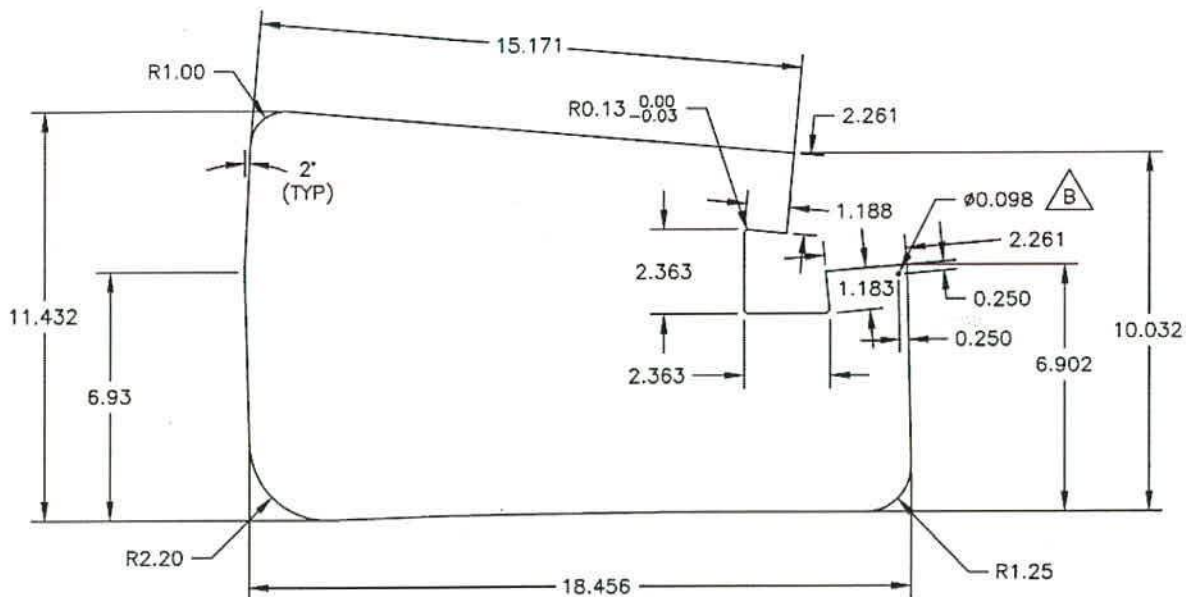
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18**D3255-1/-2 FLAT PATTERN**

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 10050

D3255-1/-2 NOTES:

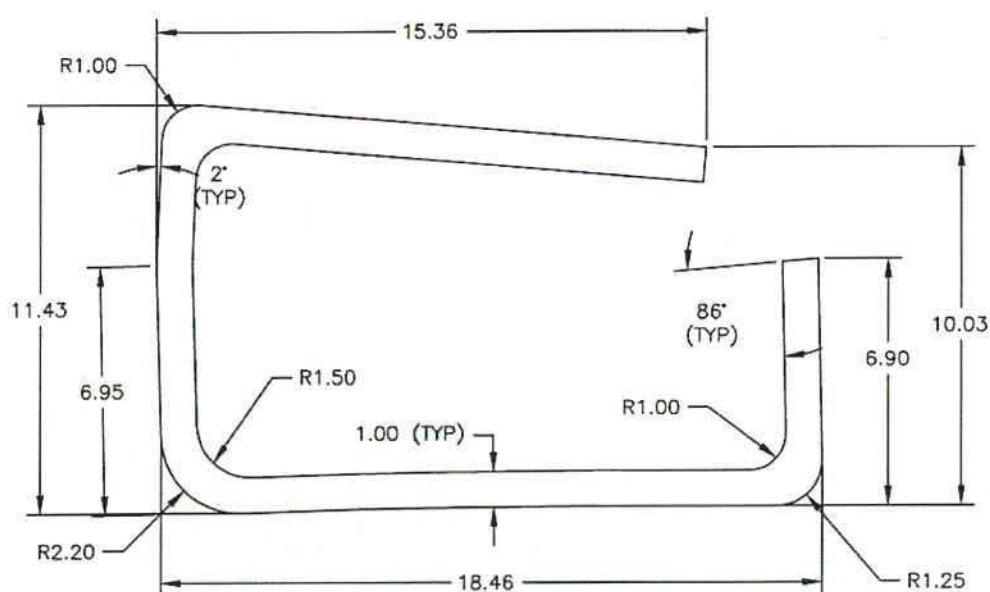
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

DESIGN JT	DRAWN BY JT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:5

RELEASED
05 01.18 [Signature]**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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 Est Rev:D ECN 1052 07-11-06 DD verified by: EC

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 Due Date : 07/08/2008 Qty: 2 Um: Each

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REFERENCE ONLY

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JLD 08-8-11



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 Batch: _____

4.0 D3255042 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Access Panel Assembly
 Batch: _____

5.0 AN3C3A Bolt



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)
 Bolt
 Batch: _____